

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011831**Date Inspected:** 29-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard – 8CE.

Notification No: 005144.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel; except for the Deck Panel (DP) welds, which are not MT tested by ZPMC QC. The below mentioned DP welds are 100% MT tested by Caltrans QA. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

PP70-DP418-001 – 142, 147, 152, 155, 160, 168, 171, 176 & 179.

PP68-DP337-002 – 047, 052, 057, 060, 065, 068, 073 & 076.

PP68-DP499-001 – 036, 041, 046, 049, 054 & 057.

PP58-DP472-001 – 058, 063, 068, 071, 076, 079, 084, 087, 092 & 095.

PP69-SSD17A-001 – 003 & 004.

PP68-SSD16A-001 – 003 & 004.

PP67.5-CSD2-001 – 053 to 074.

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PP68-CSD4-001 – 073, 074, 083 to 094, 106 to 111, 135 to 142.

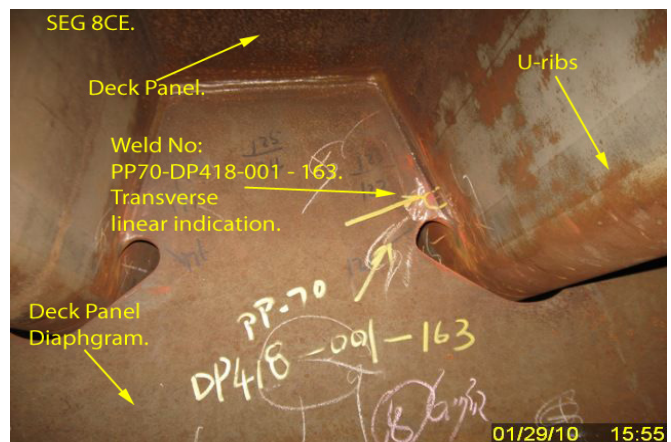
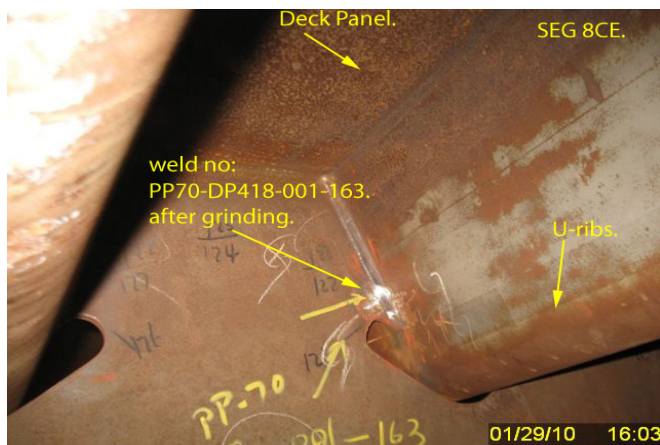
The following weld did not appear to comply with the applicable contract documents:

PP70-DP418-001 – 163.

One (1) transverse linear indication was discovered measuring approximately 9mm in length. The member is identified as the deck panel diaphragm, fillet weld connection to U-ribs. This indication is located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA informed ZPMC Quality Control (QC) identified as Mr. Wang Xiang Pin and American Bridge Fluor (ABF) QA identified as Mr. Peter Shaw of this issue and that an incident report would be generated.

For further information, please see the attached photos.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
